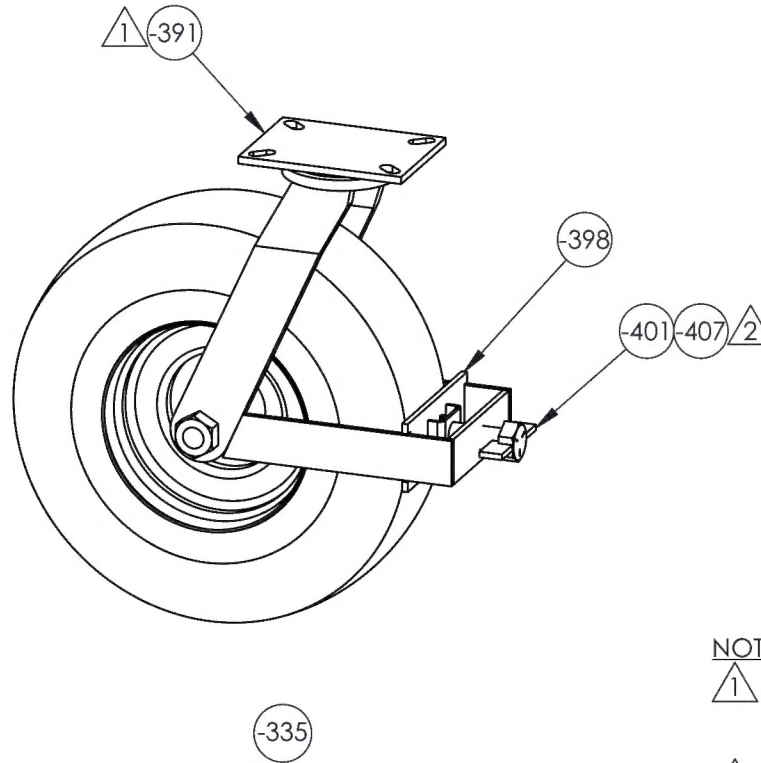


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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	4/26/2017	SM	JAG



CASTER ASSY

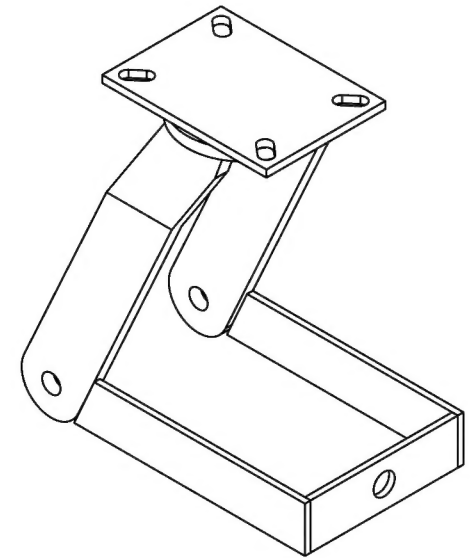
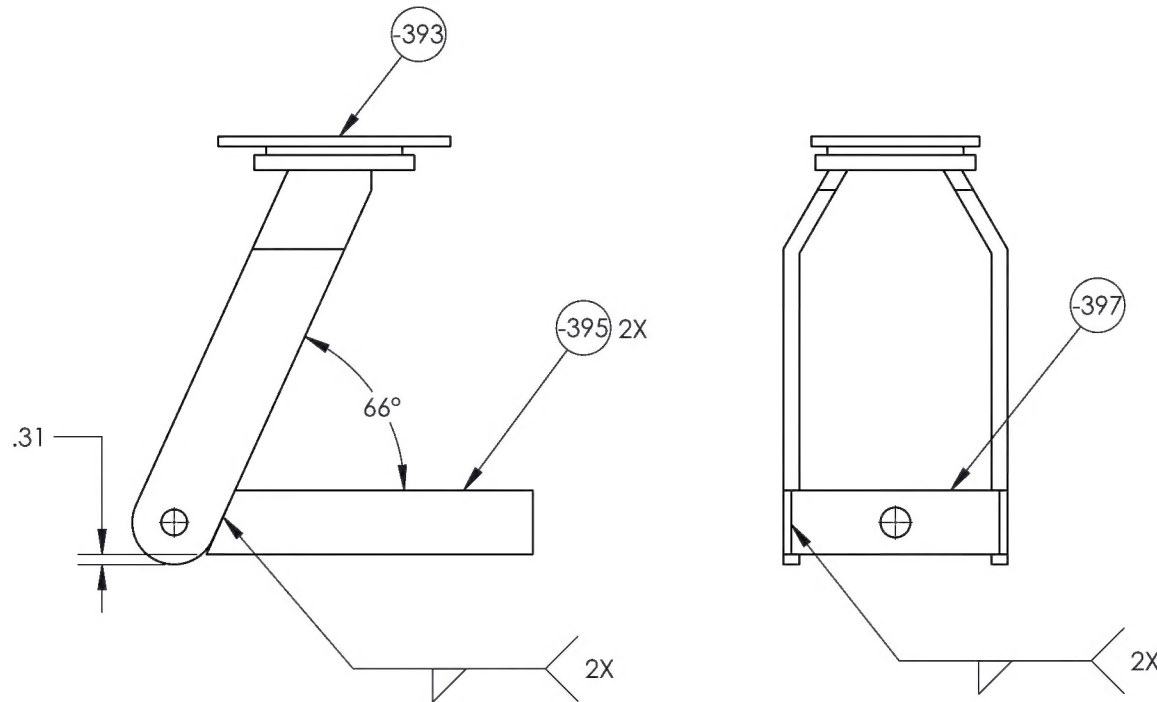
NOTES:

- 1 REMOVE TIRE AND AXEL FROM -391 PRIOR TO WELDING AND PLATING. RE-INSTALL AFTER PLATING.
- 2 INSTALL -407 SO THAT -401 CAN STILL ROTATE FREELY.

ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.				
		X		-391	1	CASTER WELDMENT			2	TITLE			
		1		-393		SWIVEL CASTER		(MCMASTER-CARR - 28035T12) MODIFIED	2	SUPPORT DOLLY, TAILBOOM			
		2		-395		BRAKE SUPPORT	A36/1018/1020 HR		3	DWG NO. RB T102012-335			
		1		-397		THREADED BRAKE PLATE	A36/1018/1020 HR		4	REV 1			
X				-398	1	BRAKE PLATE WELDMENT			5	MAT'L			
1				-399		BRAKE PLATE	A36/1018/1020 HR		6	UNLESS OTHERWISE SPECIFIED			
1				-400		BRAKE PLATE TAB	A36/1018/1020 HR		7	DIMENSIONS ARE IN INCHES			
	X			-401	1	BRAKE BOLT WELDMENT			8	.XXX ± .005 FRACTIONS ± 1/8			
	2			-403		BRAKE BOLT TAB	A36/1018/1020 HR		9	.XX ± .01 ANGLES ± 5°			
	1		B/O	-405		BRAKE BOLT	STEEL	1-14 x 3 (MCMASTER-CARR # 92865A524)	8	.X ± .1 SURFACES = 125°			
			B/O	-407	1	SPRING PIN	STEEL	1/4 x 1-1/2 (MCMASTER-CARR # 90692A746)	1	1. BREAK ALL SHARP EDGES			
	ASSM -401	ASSM -391								.015 x 45° OR .015R			
										2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
										3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009			
										USED ON MODEL			
										212, 214B, 214ST, 412			
										SCALE 1:8			
										DATE 11/15/2016			
										SHEET 1 OF 9			

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REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



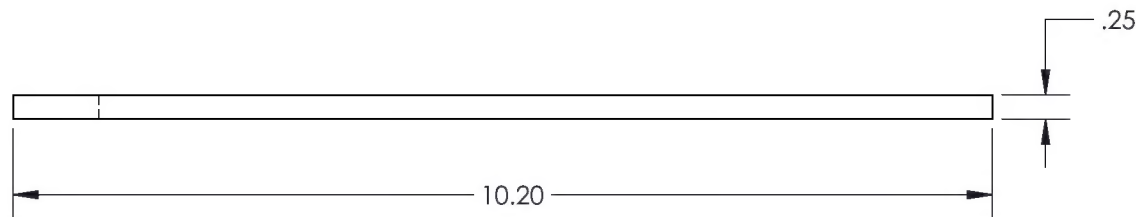
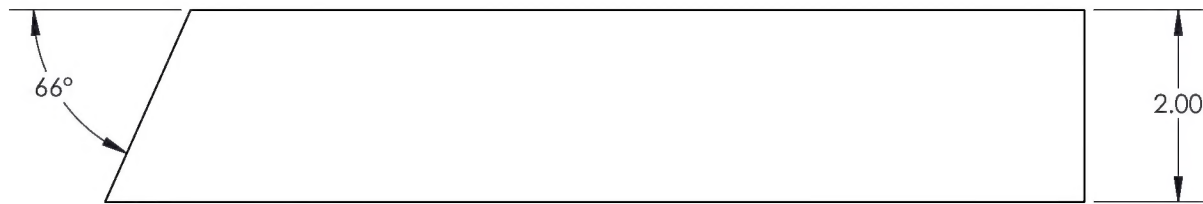
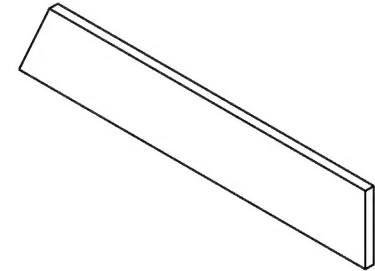
-391

CASTER WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-391</b>	REV <b>1</b>
MAT'L <b>ZINC PLATE</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC <b>ASTM B633 TYPE I SC 2</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>MACKOVJAK</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>CLOUGH</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	USED ON MODEL
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	<b>212, 214B, 214ST, 412</b>
SCALE <b>1:6</b>	DATE <b>11/15/2016</b>
SHEET 2 OF 9	

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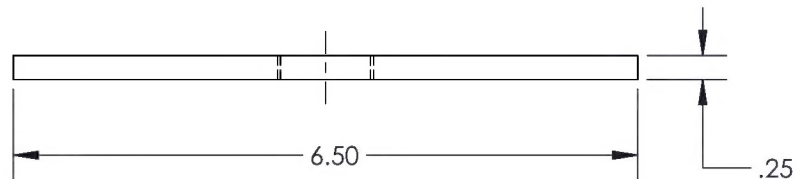
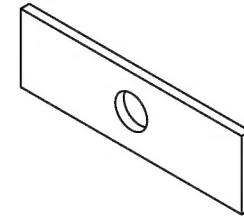
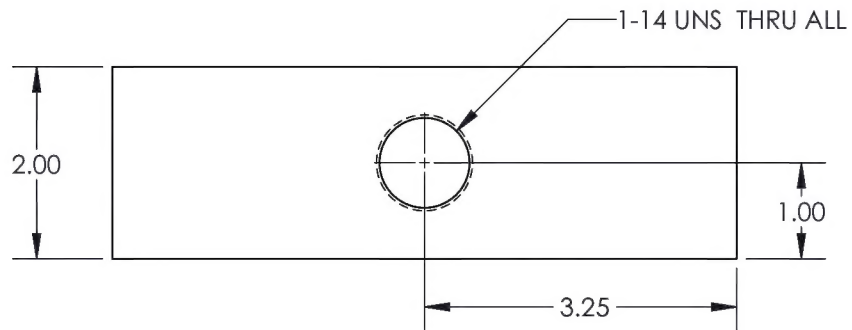
(-395)

BRAKE SUPPORT

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-395</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -391 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 11/15/2016
	SHEET 3 OF 9

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-397)

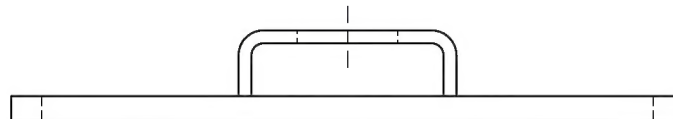
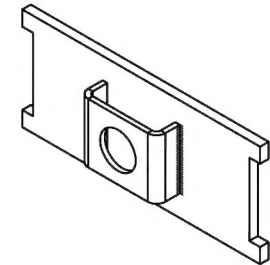
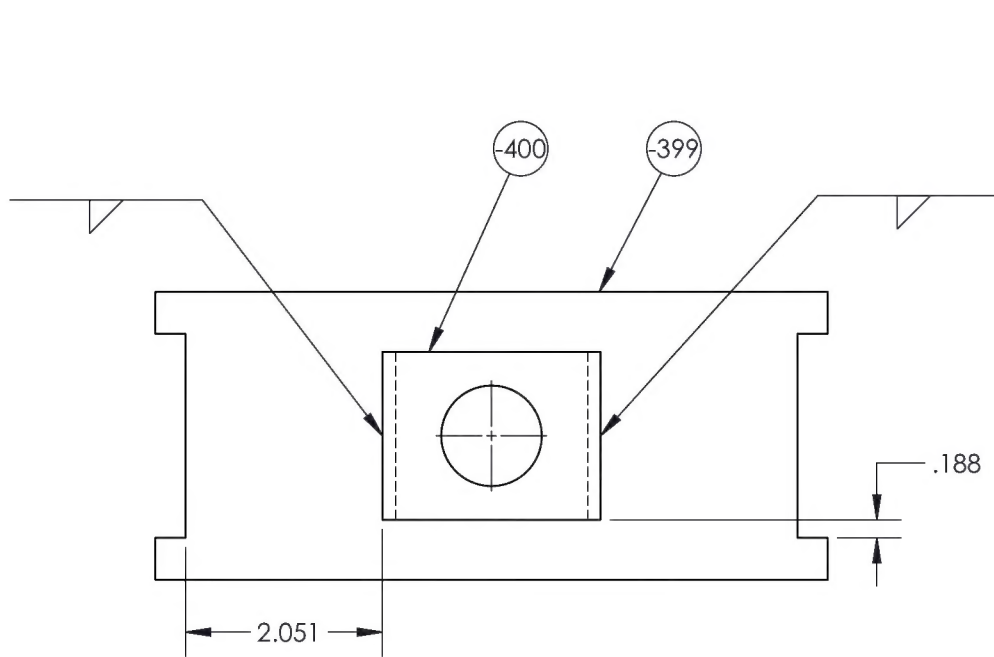
THREADED BRAKE PLATE



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-397	
REV		1	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -391 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: MACKOVJAK		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:2		DATE 11/15/2016	
		SHEET 4 OF 9	

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				APPROVED



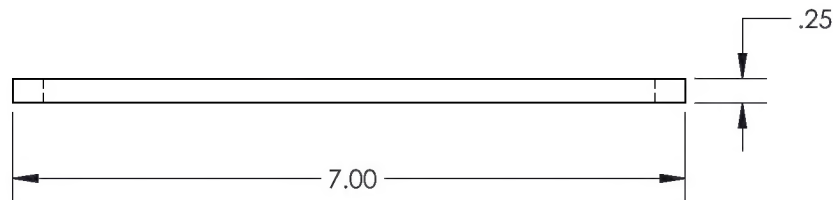
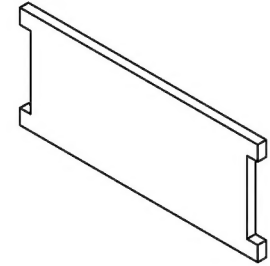
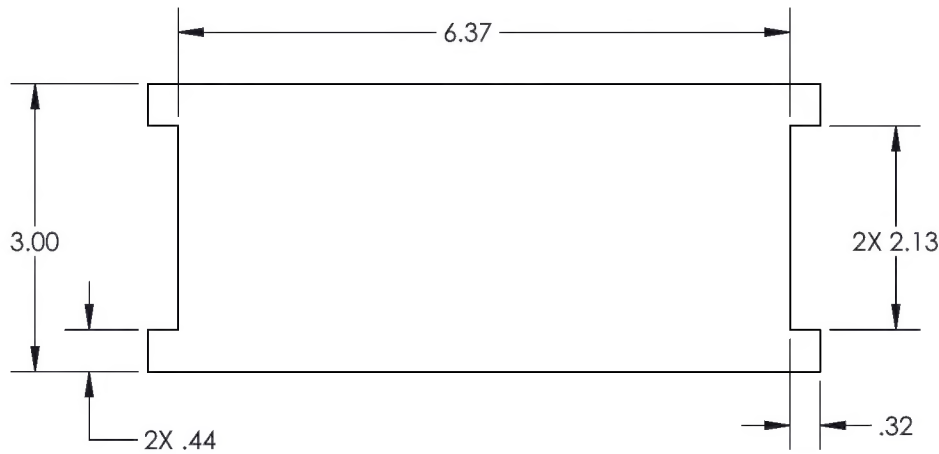
-398

BRAKE PLATE WELDMENT

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-398</b>	REV <b>1</b>
MAT'L <b>ZINC PLATE</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC <b>ASTM B633 TYPE I SC 2</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>MACKOVJAK</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>CLOUGH</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	USED ON MODEL
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	<b>212, 214, 214ST, 412</b>
SCALE <b>1:2</b>	DATE <b>11/15/2016</b>
SHEET 5 OF 9	

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				APPROVED



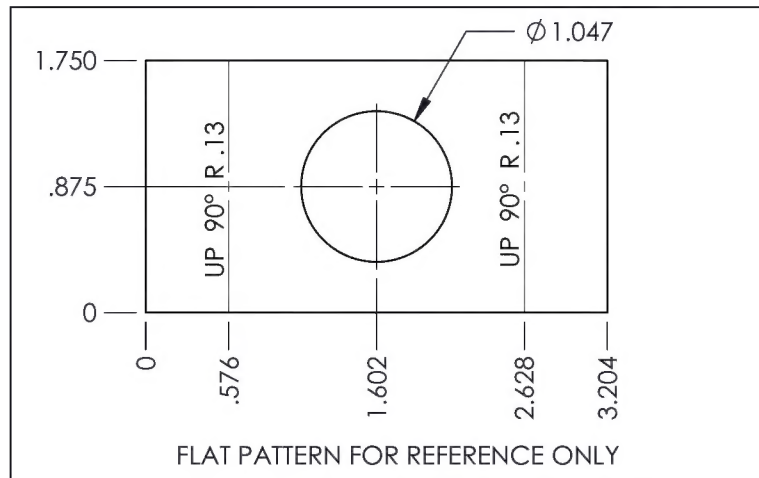
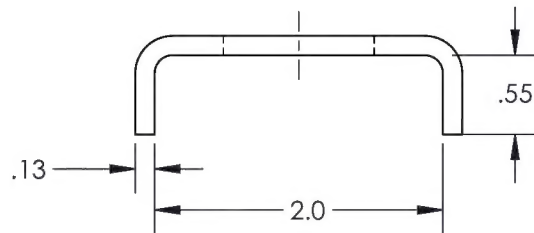
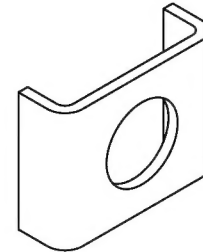
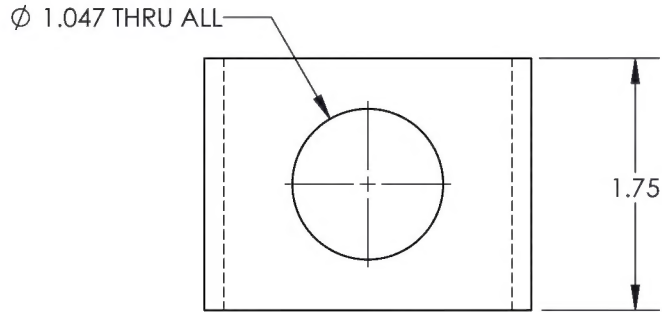
-399

BRAKE PLATE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-399</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -398 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 11/15/2016
	SHEET 6 OF 9

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-400

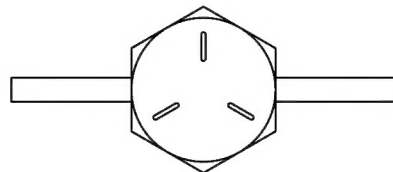
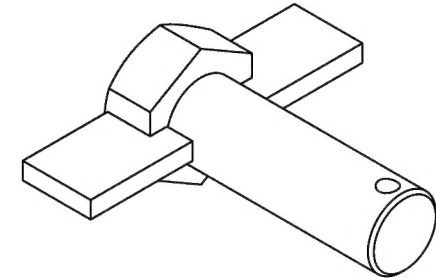
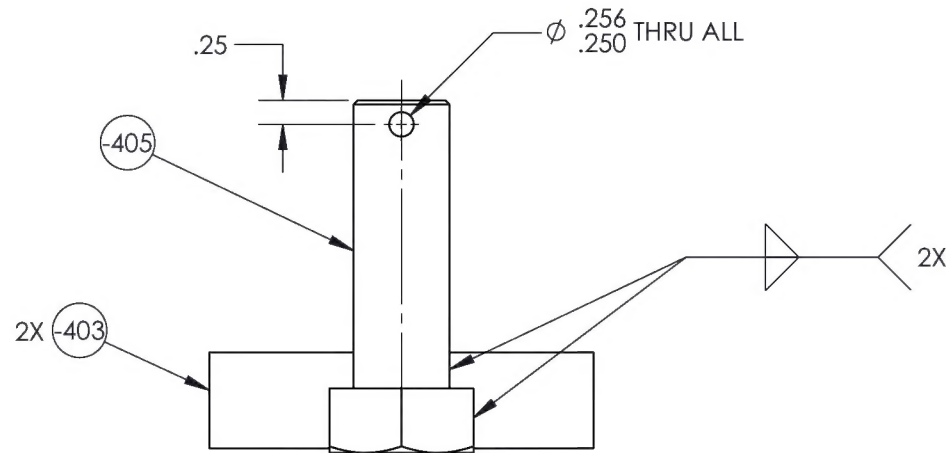
BRAKE PLATE TAB

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-400</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE -398 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>MACKOVJAK</b>	USED ON MODEL
CHECKED: <b>CLOUGH</b>	212, 214B, 214ST, 412
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	
SCALE <b>3:4</b>	DATE <b>11/15/2016</b>
SHEET 7 OF 9	



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-401

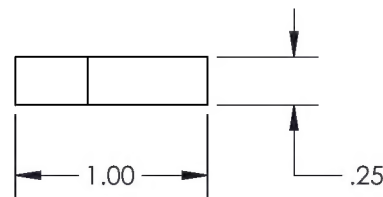
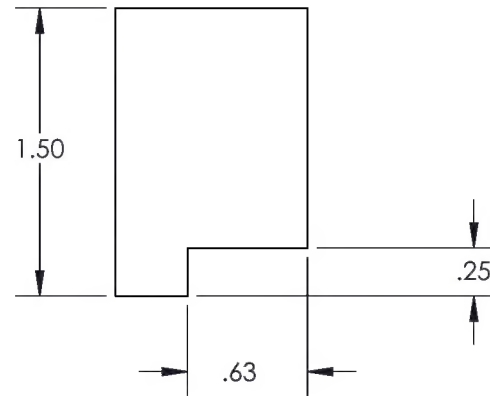
BRAKE BOLT WELDMENT

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-401</b>	REV <b>1</b>
MAT'L <b>ASTM B633 TYPE I SC 2</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT <b>ZINC PLATE</b>	.XXX ± .010 FRACTIONS ± 1/8
FINISH <b>ZINC PLATE</b>	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
SPEC <b>ASTM B633 TYPE I SC 2</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>MACKOVJAK</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>CLOUGH</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	USED ON MODEL
QA APPR: <b>LINDSAY</b>	<b>212, 214B, 214ST</b>
APPROVED: <b>GILBERT</b>	
SCALE <b>1:2</b>	DATE <b>11/15/2016</b>
SHEET 8 OF 9	



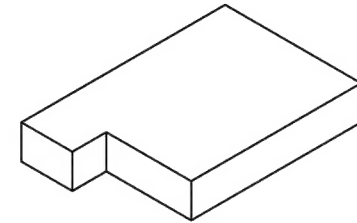
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				APPROVED



-403

BRAKE BOLT TAB



<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-403</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -401 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 11/15/2016
	SHEET 9 OF 9